









Work Order ID 64330




Thursday, December 02, 2010 1:37:59 PM

Page 1

Item ID:	D3622-5	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Ball Stud					
Start Date:	12/2/2010	Start Qty:	20.00		Cust Item ID:	
Required Date:	12/15/2010	Req'd Qty:	20.00		Customer:	

Reference:

Approvals:	Process Plan:		Date:	10/20/2	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3622	C								
100	Hardinge CNC LATHE SMALL	0.00				20	0		
	Hardinge	Memo							
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO F966 & DWG D3622 , FOLIO REV: <u>C</u> DWG REV: <u>C</u> 2-DEBURR AS REQUIRED		SA	10/12/21					
110	QC2- Inspect parts off machine FAI/FAIB	0.00				20	0		
	QC	Memo							
Quality Control			SA	10/12/21					
120	QC8- Inspect parts - second check	0.00				20	0		
	QC	Memo							
Quality Control			L.A	10/12/22					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3622-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Ball Stud

Start Date: 12/2/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: 670

0.00



Packaging

Memo

0.00

Packaging

CK 10/12/22 (20)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/12/22

10/12/22
(20)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Thursday, December 02, 2010 1:38:03 PM

Work Order ID: 64330



Parent Item: D3622-5



Parent Item Name: Ball Stud


Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 10-09-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500  303 HEX BAR .500		Purchased	No			100	f	121.3480	0.108	2.273684		01/12/22	

Location

Loc Qty

Loc Code

MAT037

121.348

109778

99.548

109846

21.8

2.884

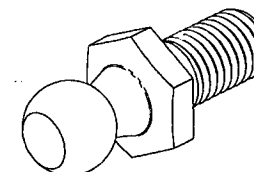
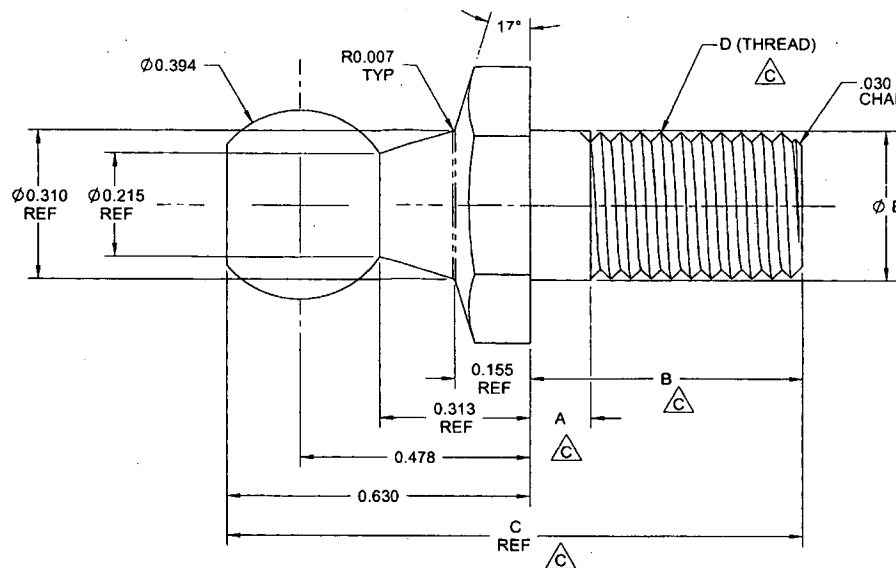
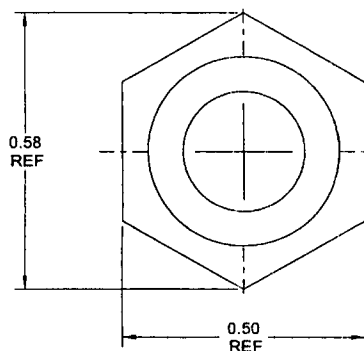
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

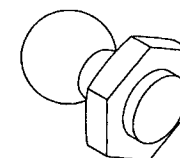
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D3622-1 BALL STUD SHOWN



D3622-11 BALL STUD SHOWN

PART NUMBER	DIM A	DIM B	DIM C	WEIGHT (LBS)	THREAD D	Ø E MIN	Ø E MAX
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840	0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270	0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053	0.3125

D3622-X BALL STUD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44330 P10-12-09

- NOTES:
1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
7) WEIGHT: SEE D3622-X TABLE

RELEASED
2010-09-23
JPH

C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3622 TITLE BALL STUD SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.07.20		

W/O:		WORK ORDER CHANGES					
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